



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D3571-3

Job Sheet 194652



Part No: D3571-3

Job Qty: 8 pcs

Part Name: Guide



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/7/19

Job Tracking No:

Due Date: 5/27/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A IPP Rev:A New Issue 07-02-01 JLM IPP Rev:B Remove manual Machinig 08-05-26 JLM Verified By:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier			
100	Bandsaw - 1	8 pcs	5/27/19	5/27/19	0.00	0.96	Bandsaw - 1		DAS 52 9-89	19/05/12
110	HAAS 4 Axis - B4B	8 pcs	5/27/19	5/27/19	0.47	4.97	HAAS - 1 - B4B		52 9-89	19/05/12
							HAAS - 2 - B4B			
							HAAS - 3 - B4B			
							HAAS - 4 - B4B			
120	QC 2	8 pcs	5/27/19	5/27/19	0.00	0.00	QC 2 - 1			
							QC 2 - 12			
							QC 2 - 14			
							QC 2 - 17			
							QC 2 - 19			
							QC 2 - 2			
							QC 2 - 20			
							QC 2 - 22			
							QC 2 - 23			
							QC 2 - 25			
							QC 2 - 32			
							QC 2 - 33			
							QC 2 - 35			
							QC 2 - 39			
							QC 2 - 4			
							QC 2 - 40			
							QC 2 - 44			
							QC 2 - 45			
							QC 2 - 48			
							QC 2 - 49			
							QC 2 - 50			
							QC 2 - 51			
							QC 2 - 52			
							QC 2 - 57			
							QC 2 - 62			



Container No: S181807



Part: D3571-3

Job No: 194652

Serial No/Batch: S181807

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
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Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 05/16/19

Plex 5/7/19 8:47 AM Dart.lajeunesse.marie

130 QC 8	8 pcs	5/27/19	0.00 0.00	QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 8 - 12	mL 19/05/16
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
140 Handfinish - 1-1 Chemical- B4B	8 pcs	5/27/19	0.00 0.34	Handfinish - 1 - 1 - B4B	BEB 19-05-21
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 -	

				B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
150 Powdercoat - 3 Grey Sand - B4B	8 pcs	5/27/19	0.00 0.24	Powdercoat - 1 - B4B	
				Powdercoat - 2 - B4B	
				Powdercoat - 3 - B4B	
				Powdercoat - 4 - B4B	
160 QC 3	8 pcs	5/27/19	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	
				QC 3 - 19	
				QC 3 - 43	
				QC 3 - 24	
170 Packaging 3-1 - Stock - B4B	8 pcs	5/27/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	

BK 19-5-23.

150 Powdercoat - 3 Grey Sand - B4B
 8 pcs
 5/27/19 0.00 0.24
 START: 1:10 OUT: 3:20 FINISH: 1:40

DAS
 MAY 23 2019 40
 9-89

PC 51040

				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
180 QC 21 - SA	8 pcs	5/27/19	0.00 0.00	QC 21 - SA - 21	<i>21</i>
				QC 21 - SA - 70	<i>21</i>
				QC 21 - SA - 53	<i>21</i>

MAY 24 2019

Part Op **100** - Cut blank 2.90 " long
 Descriptions: **110** - (HAAS CNC Vertical Machine), 1- Mill as per Folio FA681 Rev: A & Dwg D3571 Rev: A 2-Deburr per dwg D3571
120 - (QC2- Inspect parts off machine FAI/FAIB)
130 - (QC8- Inspect parts - second check)
140 - (Chemical Conversion Coat per QSI005 4.1)
150 - (Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3), START TIME: _____ OVEN TEMPERATURE: _____
 FINISH TIME: _____
160 - (QC3- Inspect Part Finish)
170 - (Identify as per dwg & Stock Location: _____)
180 - (QC21- Final Inspection - Work Order Release)

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M6061T6B0.750X01.500	6061-T6 Bar .750 X 1.50	1.9280 ft (.241 ea)	100-Bandsaw - 1	<i>5168972</i>

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M6061T6B0.750X01.500	2	113	0

Part Specifications
Specifications could not be found.

*MAT
used
1.966*

DART AEROSPACE LTD		Work Order: 194652
Description: Guide		Part Number: D3571-3
Inspection Dwg: D3571	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.698	+/-0.010	0.699	✓		Vern.	
2.75	+/-0.030	2.750	✓		Vern.	
1.38	+/-0.030	1.38	✓		Vern.	
1.25	+/-0.030	1.249	✓		Vern.	
0.63	+/-0.010	0.630	✓		Vern.	
0.031 chamfer	+/-0.010	0.030	✓		Vern.	
Ø0.500	+0.006/-0.001	0.501	✓		Vern.	
Ø0.201	+0.005/-0.001	0.201	✓		Vern.	
R0.25	+/-0.030	0.250	✓		R.G.	
0.260	+0.000/-0.010	0.254	✓		G.P.	
Ø0.385 x 100°	+0.006/-0.001 x 0.5°	0.380 x 100°	✓		Vern.	
0.125	+/-0.010	0.125	✓		Vern.	
2.250	+/-0.010	2.251	✓		Vern.	
0.250	+/-0.010	0.249	✓		Vern.	
0.188	+/-0.010	0.187	✓		Vern.	
0.063 chamfer	+/-0.010	0.063	✓		Vern.	

Measured by: DJP	Audited by: [Signature]	Prototype Approval:	N/A
Date: 19-05-15	Date: 19/05/16	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.04.16	New Issue	KJ/JLM [Signature]	[Signature]

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					